

Date: Monday, 11/05/2009 1:20:50 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FRAME
Job Number : 47841	
Estimate Number : 13827	
P.O. Number :	Part Number : D225217
This Issue : 11/05/2009 S.O. No. :	Drawing Number : D2252 REV G
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : G
Previous Run : 46827	Material :
Written By :	Due Date : 22/05/2009
Checked & Approved By : <u>Julie Dawson</u>	Qty: <u>8</u> Um: Each
Comment : Est Rev:A 09.03.18 New Issue EC verified by:DD	<u>12x</u>

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304TS0750W065

304 SQ Tube .75x.75x.065W



$M110839 = 2.91f$
 $M111148 = 1.33f$



Comment: Qty.: 1.7220 f(s)/Unit Total : 6.8880 f(s)



304 SQ Tube .75x.75x.065W

batch: M111148 → 5x M110839 → 7x

SY 09/05/13

2.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- Cut as per dwg D2252 *****angle is 53*****
 2- Deburr and remove identification markings on tube

SY 09/05/13 (12x)

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SY 09/05/13 (12)

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Basket

PD 09-05-13 (12)

5.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/13 JA

Job Completion



MF 09-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2252-041	BASKET ASSEMBLY
3		X	D2252-043	LID ASSEMBLY
7	2	2	D2221-1	RIB
8	5		D2235-1	RIB
9	2	2	D2252-1	FRAME
10		2	D2252-7	FRAME
11	1		D2252-9	FRAME
12	1		D2252-11	FRAME
13	1		D2252-13	FRAME
14	1		D2252-15	FRAME
15	4		D2252-17	FRAME
16		1	D2252-23	FRAME
17	2		D2253-1	LUG
18	2		D2254	GUSSET
19	1	1	D2327-3	BUSHING
20		1	D2329	LABEL PLATE
21	4	2	D2581	MOUNTING CHANNEL
22		2	D2989-19	RIB
23	3		D3748-1	HINGE HALF
24		3	D3749-1	HINGE HALF

G

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WORK ORDER
NO. 1788

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

RELEASED
9/02/18

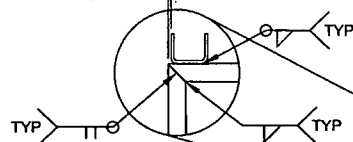
G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2232-1/-3; STRETCHED LID FROM 95.27" TO 96.00"; ITEM 7 REPLACES D2252-3/-19; ITEM 19 (ON LID) REPLACES D2327-1; ITEM 22 REPLACES D2252-21; UPDATED TOOLING (ZN A6-5). P/N REASON: SEE PAR#09-006.	MB	09.02.03
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. SHT 2 VIEWS INVERTED FOR CLARITY. FRAME MATERIAL THICKNESS WAS 0.080.	AJS	08.08.11
E	INCORPORATED D1 & D2. ADDED D2231-1/-3 & D2252-19.	MB	05.11.10
D	MODIFIED LATCH, D2581 WAS D2255-3	BK	99.09.14
C	RE-DRAWN	BK	95.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN	JB		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.02.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. G
D2252 SHEET 1 OF 6
TITLE SCALE
BASKET ASSEMBLY (206L) NTS

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G 10 0.13
2 PL, REF



WELD ALL JOINTS
AS SHOWN

D2252-1

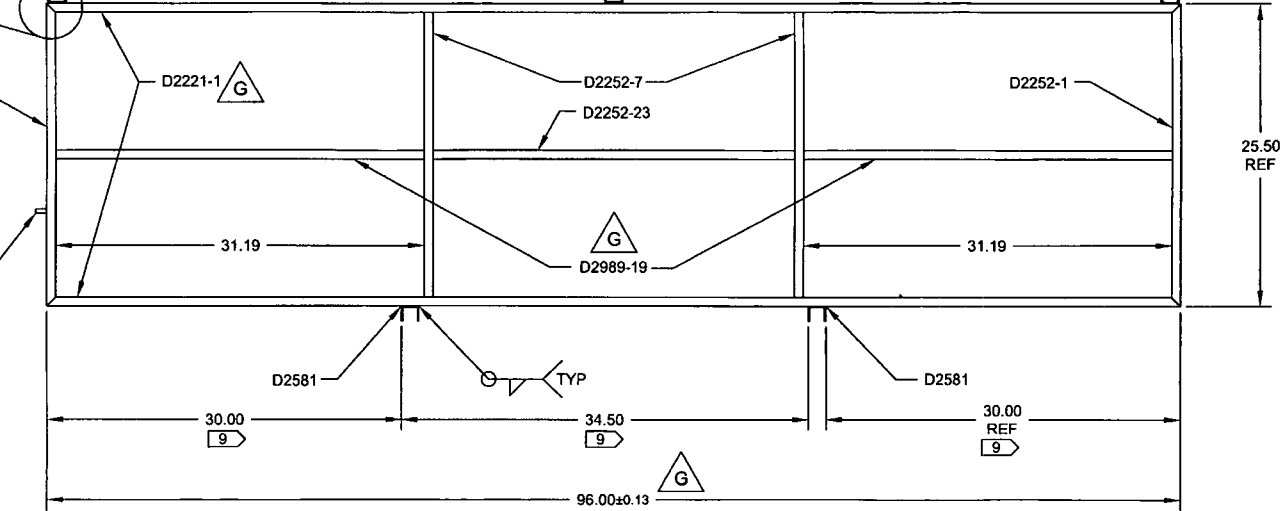
D2221-1 G

10 48.00
REF

G

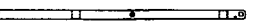
D3749-1
3 PL G

G D2327-3
REF
SEE DETAIL F
B2-5



A
A D7-5

D3749-1
REF G



WELD ALL JOINTS
AS SHOWN

D2252-043 LID FRAME

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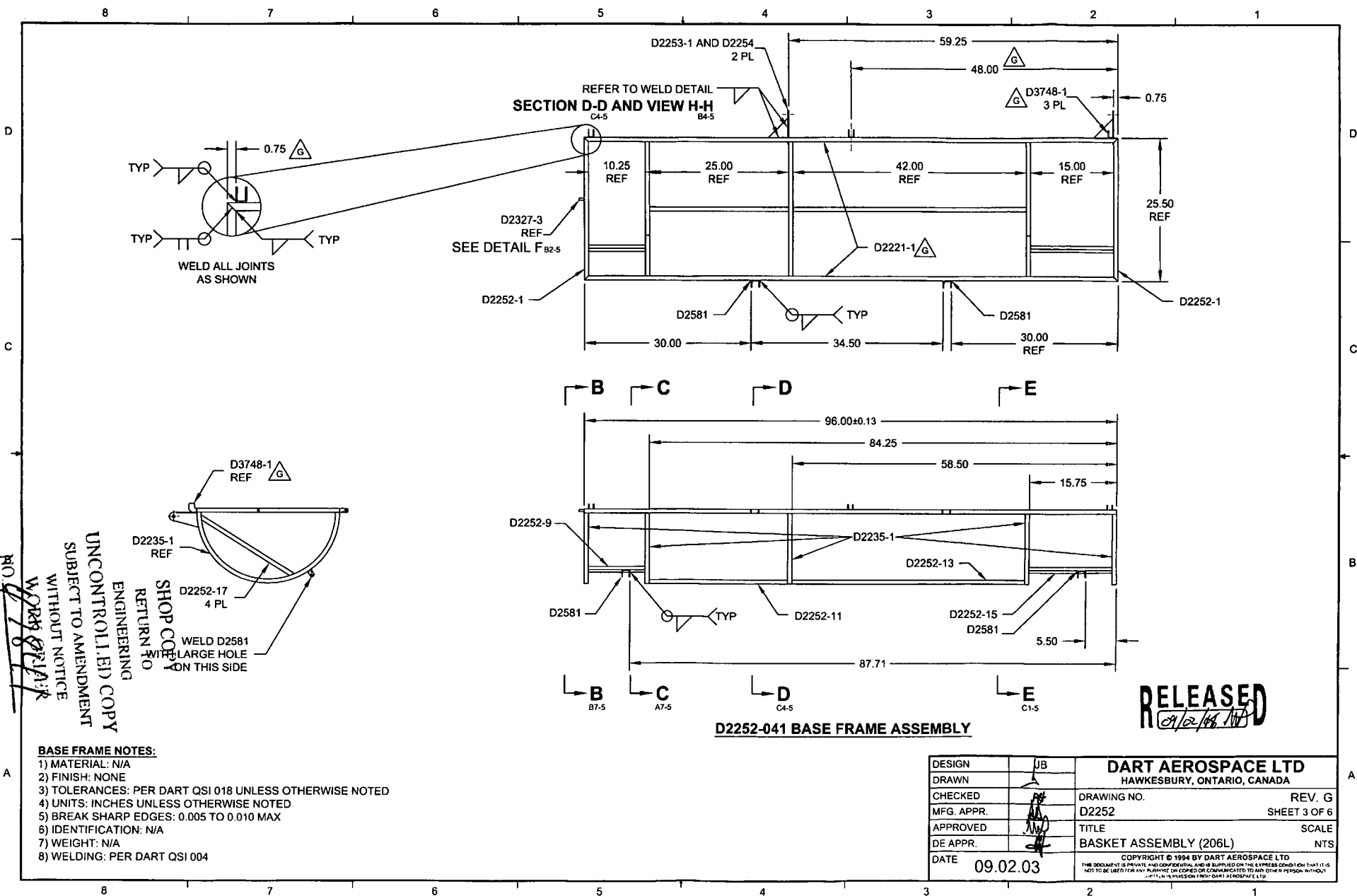
LID FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) ALIGN WITH ADJACENT D2581 ON BASE
- 10) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOCATED ON D2252-041 BASKET BASE ASSEMBLY

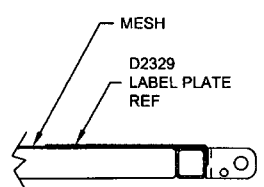
G

DESIGN	B	DART AEROSPACE LTD	REV. G
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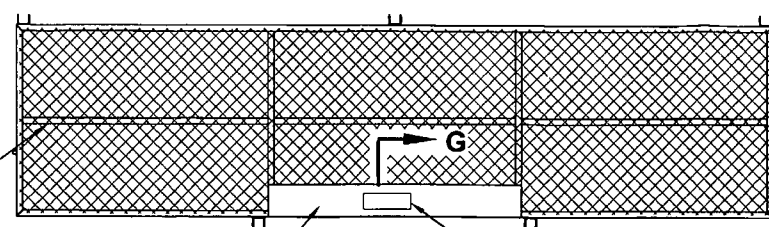


8 7 6 5 4 3 2 1



SECTION G-G C3-4
ROTATED 90° CCW

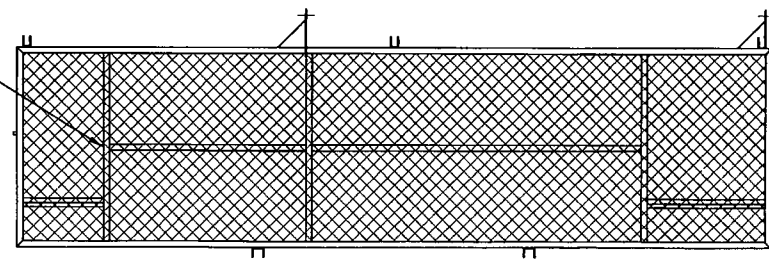
TACK WELD EACH
STRAND END OF
STEEL MESH TO FRAME



D2329 LABEL PLATE
CENTER ON THE
BASKET LID

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE

D2252-043 LID ASSEMBLY



D2252-041 BASE ASSEMBLY

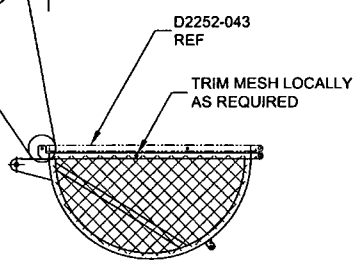
D3748-1
3 PL, REF

TRANSFER MARK FROM D3749-1
HINGE HALF ON D2252-043 LID ASSY,
DRILL Ø0.261 THRU

0.200
PRIOR TO DRILLING Ø0.261
HOLE THRU D3748-1 AND D3749-1

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D2252-043
REF

TRIM MESH LOCALLY
AS REQUIRED

ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

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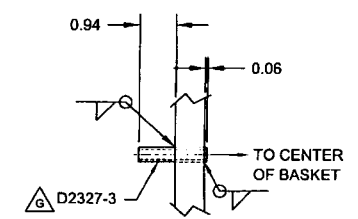
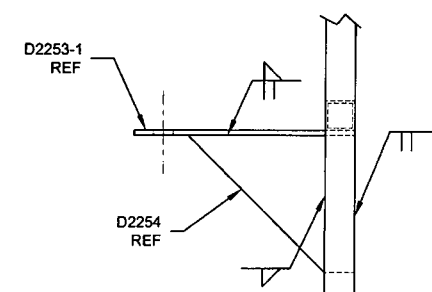
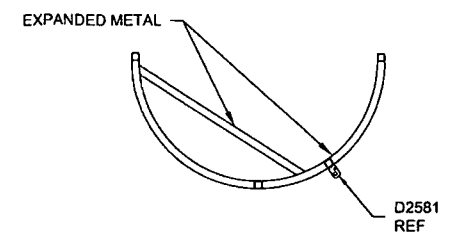
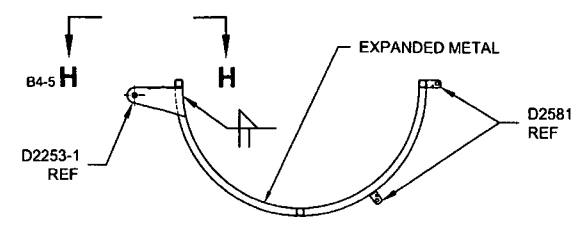
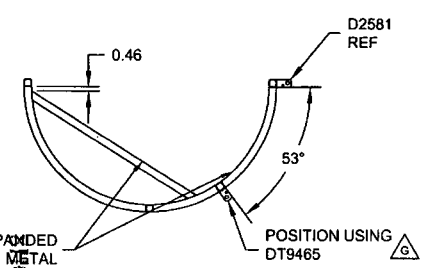
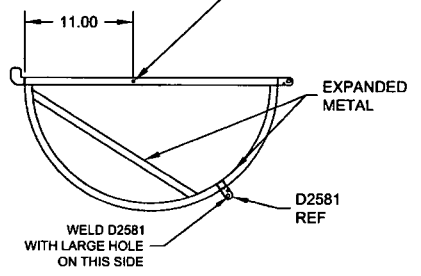
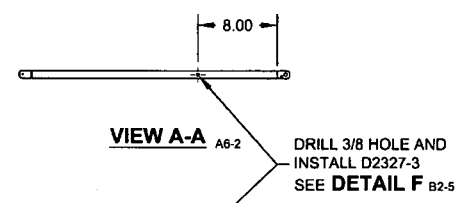
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SHEET 4 OF 6
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



DETAIL F C5-3
SPACER INSTALLATION C6-2

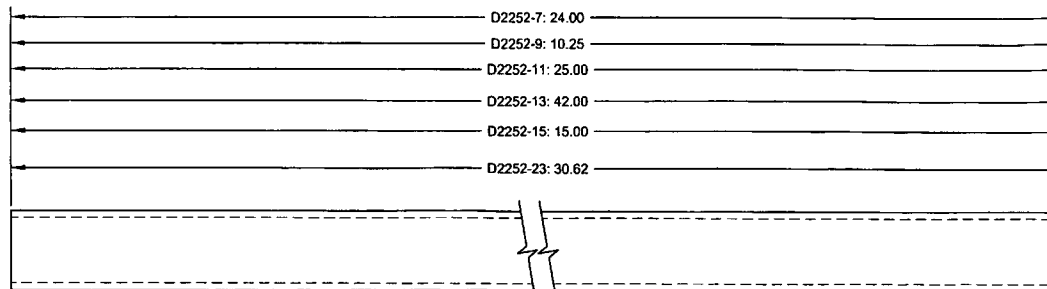
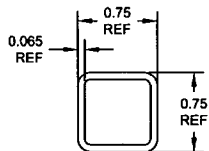
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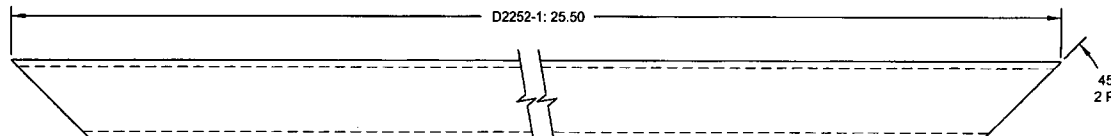
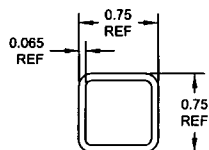
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8 7 6 5 4 3 2 1

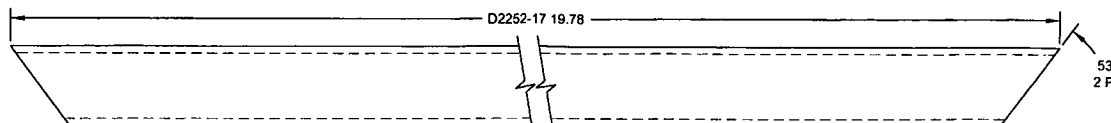
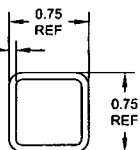
8 7 6 5 4 3 2 1



D2252-7 FRAME
D2252-9 FRAME
D2252-11 FRAME
D2252-13 FRAME
D2252-15 FRAME
D2252-23 FRAME



D2252-1 FRAME



D2252-17 FRAME

- NOTES:**
 1) FRAME MATERIAL: SEE SHEET 1
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A

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